



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6305G01232-3G-5

Job Sheet 186994



Part No: RBW6305G01232-3G-5

Job Qty: 4 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/23/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6305G01232-3G Rev 3 IPP Rev A 18.02.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	12/14/18	12/14/18	0.00	0.00	Start Up Machining-2		
110	CNC Lathe	4 pcs	12/14/18	12/14/18	0.00	1.00	SL-154		
120	QC	4 pcs	12/14/18	12/14/18	0.00	0.00	QC2 Machining-4		
130	QC	4 pcs	12/14/18	12/14/18	0.00	0.00	QC8 Machining-4		
150	Outsource	4 pcs	12/14/18	12/14/18	0.00	0.00	Outsource3		
160	Packaging	4 pcs	12/14/18	12/14/18	0.00	0.00	Packaging2		
170	QC	4 pcs	12/14/18	12/14/18	0.00	0.00	QC6		
180	Packaging	4 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3-1		
190	QC21-SA	4 Ea	12/14/18	12/14/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG. FB945 FOLIO REV: _____ DWG REV: 9-89 2-Debur 9-89
Descriptions: 150 - -Issue P/O to Groupe Altech: P/O 42318 -Cadmium plating, QQ-P-416F TYPE II, CLASS II -Color: Yellow
-Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R0.750	AISI 4140 Quenched &Tempered Steel Round Bar 0.750" Dia.	.3040 ft (.076 ea)	90-Start up Operation	
			7/8" 4140QT -> 5009788	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140QT-R0.750	0	27	0

Part Specifications

could not be found.

Plex 11/23/18 1:27 PM Dart.lajeunesse.marie



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S145786



Part: RBW6305G01232-3G-5

Job No: 186994

Serial No/Batch: S145786

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 01/17/19

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12 288

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

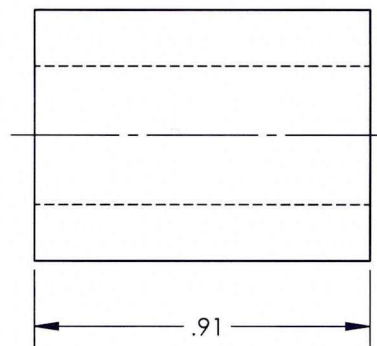
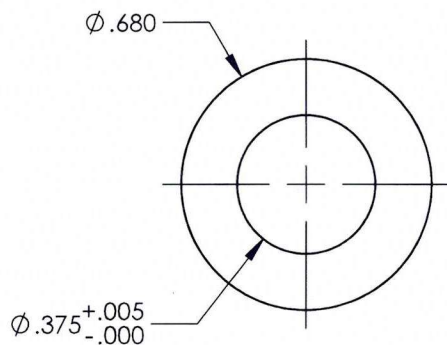
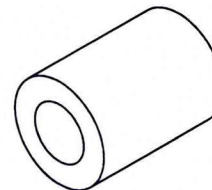
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER :							

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-5 CH'D DIM WAS Ø.381 IS Ø.375 +.005-.000.	5/10/2013	CFS	GE
3	15-0321	-5 CH'D MATERIAL CALLOUT WAS 4140 Q&T IS 4140 Q&T / 4142 Q&T.	10/2/2015	RJC	JAG



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 186994 MMS
 18-11-23

(-5)

SPACER

TITLE GIMBAL TORQUE TUBE BUSHING REMOVER	
DWG NO. RBW6305G01232-3G-5	REV 3
MAT'L 4140 Q&T / 4142 Q&T	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED <i>D Weil</i> HEAT TREAT FINISH CAD PLATE YELLOW
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SPEC QQ-P-416, TYPE II, CLASS II USED ON MODEL AGUSTA
SCALE 2:1	DATE 4/7/2011
SHEET 4 OF 4	



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042318



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042318
PO Date: 1/18/19
Due Date: 1/24/19
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	186994	RBW6305G01232- 3G-5	Spacer -Issue P/O to Groupe Altech: P/O -Cadmium plating, QQ- P-416F TYPE II, CLASS II -Color; Yellow -Certificate of Conformity is required	Firmed	-	1/24/19	4 pcs	0 pcs	4 pcs	\$49.166666700/pcs	\$196.67
2	188772	RB T102137-107	Tool Lifting -Issue P/O to Groupe Altech: P/O -RB T102137- 107-103 ✓ -RB T102137- 107-105 ✓ -RB T102137- 107-107 ✓ -RB T102137- 107-109 ✓ -Cadmium plating, QQ- P-416F TYPE II, CLASS II -Color; Yellow -Certificate of Conformity is required	Firmed	-	1/24/19	1 pcs	0 pcs	1 pcs	\$49.166666700/pcs	\$49.17

DA
36
9-86



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PURCHASE ORDER PO042318



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	183795	RB T102137-111	Lifting Tool -Issue P/O to Groupe Altech: P/O -Cadmium plating, QQ-P416F TYPE II, CLASS II -Color: Yellow - Certificate of Conformity is required	Firmed	-	1/24/19	1 pcs	0 pcs	1 pcs	\$49.166666700/pcs	\$49.17
1x JAN 30 2019 Cix includes 8pcs											

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/21/19 9:05 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(016127-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

016127 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
29-Jan-2019		Aman		042318				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW6305G01232-3G-5 Rev. #186994	RBW6305G01232-3G-5 01 -CAD YELLOW 500 [CADMIUM YELLOW 500] QQ-P-416F TYPE 2 CLASS 2	CADMIUM CH	4	4	0	0	0
2	RBT102137-107-103 Rev.	RBT102137-107-103 01 -CAD YELLOW 500 [CADMIUM YELLOW 500] QQ-P-416F TYPE 2 CLASS 2	CADMIUM CH	1	1	0	0	0
3	RBT102137-107-105 Rev. #188772	RBT102137-107-105 01 -CAD YELLOW 500 [CADMIUM YELLOW 500] QQ-P-416F TYPE 2 CLASS 2	CADMIUM CH	1	1	0	0	0
4	RBT102137-107-107 Rev.	RBT102137-107-107 01 -CAD YELLOW 500 [CADMIUM YELLOW 500] QQ-P-416F TYPE 2 CLASS 2	CADMIUM CH	1	1	0	0	0
5	RBT102137-107-109 Rev.	RBT102137-107-109 01 -CAD YELLOW 500 [CADMIUM YELLOW 500] QQ-P-416F TYPE 2 CLASS 2	CADMIUM CH	1	1	0	0	0
6	RBT102137-111 Rev.	RBT102137-111 01 - CAD YELLOW 500 [CADMIUM YELLOW 500] QQ-P-416F TYPE 2 CLASS 2	CADMIUM CH	1	1	0	0	0
7	STRIP CAD CHARGE Rev. #183795	STRIP CAD CHARGE 01 -STRIP [STRIP]	STRIP MIN-CHG	1	1	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.